

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000090**Date Inspected:** 05-Mar-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Liu**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Component:** N/A**Bridge No:** 34-0006**Summary of Items Observed:**

The CALTRANS Quality Assurance (QA) Inspector, Alfredo Acuna was present for the mechanical testing on the welding qualification tests for the procedure qualification records (PQR)HP 200706 and PQR HP 200709 scheduled for this project. The testing was at the ZPMC facility in Shanghai, China for the San Francisco Oakland Bay Self Anchored Suspension Bridge. The QA Inspector observed tensile test on reduced sections and all weld metal specimens along with side bends, Charpy Vee Notch (CVN) and macroetch tests. The tests were performed per the AWS D1.5, Section 5.18 requirements. The tests appeared to comply with the contract documents. The QA Inspector issued a lot number of B71-004-07 for PQR HP 200706 and B71-005-07 for PQR HP200709 after the completion mechanical testing. See TL_6032s for details of this test.

The digital photograph below shows the test coupons tested.



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Summary of Conversations:

The QA inspector had a conversation with Caltrans Task Leader Dave McClary. Mr. McClary relayed to the QA inspector that it was approved by Caltrans Structural Material representative Mazen Wahbeh to use submerged arc welding (SAW) process with amperages that exceed 600 A when connecting both sides of the groove. Mr. McClary responded to the QA inspector question formulated on 02/28/07.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Acuna,Alfredo	Quality Assurance Inspector
Reviewed By:	McClary,David	QA Reviewer
